Work Order ID 63370 Thursday, October 28, 2010 10:13:41 AM			•		P	Page 1
Item ID: D206-642-541 Revision ID: Item Name: Replacement Skidtube	Accept		Setüp	Start Stop		
Start Date: 10/28/2010 Start Qty: 1.00 Required Date: 11/11/2010 Req'd Qty: 1.00 Reference:		Cust Item ID: Customer:		•	1 12 6 11 14 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	6 1 (88)
Approvals: Process Plan:	Date: /// Tooling: Date: SPC (Y/N):	Date:	Run	Start Stop		
Sequence ID/ Operation Work Center ID Description	Set Up/ Run Hours	Tool ID Tool # Plan Acc Code Qty	•	•	Reject Insp Number Stan	
Draw Nbr Revision Nbr				•		

0.00

100

Document Control

IIN-D206-642

D3274

DOCUMENT CONTROL

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Rev M

Memo

Photocopy bluefile & type labels per PPP D206 642-541

CHG003 CL10112173

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W/O:			12.77.00	WORK ORDER	CHANGES				1
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Part No	:	P.	AR #:	Fault Category:	NCR: Ye	es No DQ	A:	Date: _	

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

		December of NO	`	Verification Ann				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto
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Work Order ID 63370

Thursday, October 28, 2010 10:13:41 AM



Page 2

Item ID:

D206-642-541

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Reference:

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A	pprovals:	•

Process Plan:

QC:

Date:

Tooling:

Date:

Date:

Run

Start

Stop



Stop



Sequence ID/ **Work Center ID**

110



Skidtubes

Skidtubes

Operation Description Set Up/ **Run Hours**

SPC (Y/N):

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp.

Number Stamp

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foilo 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod Batch: M11577

4- grind fivd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

10-10-28

BE10-10-29

W/O:				WORK ORDER	CHANGES				1 (t
DATE	STEP		PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):		PAR #:	Fault Category:	NCR: Y	es No D	QA:	Date: _	
	R	esolution:		Disposition:	QA: N/0	Closed: _		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto				

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Work Orde Thursday, Octob												Page 3	
Item ID: Revision ID: Item Name: Start Date: Required Date:	D206-642-54 Replacement S 10/28/2010 11/11/2010			Accept	Cust Item	ID:			Setup	Start Stop		1818 181 1881 1818 118 1181 1881	
Reference: Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		Date:	-	1		Start Stop			
Sequence ID/ Work Center II 120 HandFinish Hand Finishing	D	Operation Description Chemical Conversion Co	at per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	109
130 QC		QC3- Inspect Part Finish Memo		0.00	ulv,	· ; -							

140

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00 8 w/u/cg

Quality Control

W/O:			W	ORK ORDER CHANG	iES				3 1
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	_ NCR: Ye	s No	DQA:	Date: _	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section C	Chief Eng	QC Inspector
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Work	Order II	0 63370

Thursday, October 28, 2010 10:13:41 AM



Page 4

Item ID: **Revision ID:** D206-642-541

Accept



Setup Start



Stop

Item Name:

Replacement Skidtube

Start Date:

Required Date: 11/11/2010

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date:

Tooling:

Date:

Date:

Run

Start

Stop

Qty

Sequence ID/

Operation Work Center ID **Description**

Set Up/ **Run Hours**

SPC (Y/N):

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

150

Skidtubes Skidtubes

Skidtubes

Memo

0.00

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

Sikaflex expire date: ☐ 1/- 9-30 ☐

10-11-15

160

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

5,0/11/16

W/O:				WORK ORDE	R CHANGES					, 1
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Part No			PAR #:	Fault Category:			No DQA			·

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Quality Control

Memo

Page 5 Thursday, October 28, 2010 10:13:41 AM Item ID: D206-642-541 Accept Setup Start **Revision ID:** Stop Item Name: Replacement Skidtube **Start Date:** 10/28/2010 Start Qty: 1.00 **Cust Item ID: Required Date:** 11/11/2010 Req'd Qty: 1.00 Customer: Reference: Run Start Process Plan: ____ Date: ___ Approvals: Tooling: Date: Stop Date: OC: SPC (Y/N): Date: Sequence ID/ Operation **Tool ID** Tool # Plan Reject Set Up/ Accept Reject Insp. Work Center ID Description Qty Code Number Stamp **Run Hours Qty** 170 0.00 Skidtubes Skidtubes 0.00 Memo Skidtubes 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding 180 QC5- Inspect part completeness to step on W/O

W/O:		WORK ORDE	R CHÂNGES	Without Combined and the		-	1.1	
DATE	STEP	PROCEDURE CHANGE		Ву	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: Fault Category:	1	NCR: Yes	No DQ	A:	Date: _	

Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
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Page 6

Thursday, October 28, 2010 10:13:41 AM D206-642-541 Item ID: Accept Setup Start **Revision ID:** Stop Replacement Skidtube **Item Name:** 10/28/2010 **Start Date:** Start Qty: 1.00 **Cust Item ID: Required Date:** 11/11/2010 Req'd Qty: 1.00 **Customer:** Reference: Start **Process Plan:** Date: Tooling: **Approvals:** Stop QC: SPC (Y/N): Sequence ID/ Insp. Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center ID** Description **Run Hours** Code Qty **Qty** Number Stamp 190 0.00 Skidtubes Skidtubes 0.00 Skidtubes 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R□□Aluminum Rod□ //// 3-Grind cross bolt welds flush as per Dwg D3274. 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr. 200 QC5- Inspect part completeness to step on W/O Memo Quality Control

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W/O:				WORK ORDI	ER CHANGES	S)	, , ,
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Part No	:	P	\R #:	Fault Category:	. .	NCR: Yes	No DQ	A :	Date: _	
Resolution:			Disposition:		QA: N/C C	A: N/C Closed: Date:				
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NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
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Work Order ID 63370

Required Date: 11/11/2010

Thursday, October 28, 2010 10:13:41 AM



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Item ID:

D206-642-541

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

QC: Date:

Date:_____

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop



Stop

Sequence ID/ Work Center ID

210

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ **Run Hours**

0.00 S 10/11/19 Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Insp. Number Stamp

Quality Control

220

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

Memo

0.00 => Ml 10/11/22

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230

Powdercoat Powder Coating White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

0.00

FINISH TIME:

1 Kl 10-11-22

W/O:			W	ORK ORDE	R CHANG	ES					5 1		
DATE	STEP	PRO	CEDURE CH	ANGE		В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Ca	tegory:		_ NCR:	Yes N	lo DQ	Date:				
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Work Order ID 63370

Thursday, October 28, 2010 10:13:41 AM



Page 8

Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Oty: 1.00

Required Date: 11/11/2010 Reg'd Oty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____

Date:

_____ Date:____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start Stop

Stop



Sequence ID/ **Work Center ID**

240

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/

Run Hours 0.00

Tolular let

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

0.00

250

HandFinish

HandFinishing

Memo

0.00

0.00

10/11/22 _____

Hand Finishing

I-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. \triangle A/R \square N/A \square LPS-3 \square $\boxed{M109956}$

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

Sikaflex expire date:

260

OC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Nut Plate & Inserts

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Dart Aerospace 1	Ltd
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W/O:			W	ORK ORDER CHANG	ES				, , , ,
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	4:	Date:	
	R	esolution:	Dispositio	n:	_ QA: N/C Cld	sed:		Date:	
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DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
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Work	Orde	r ID	63370

Thursday, October 28, 2010 10:13:41 AM



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280	1		

Revision ID:	D206-642-54			Accept				s s	rt		
Start Date: Required Date: Reference:	10/28/2010 11/11/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item ID: Customer:						
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:		ŀ	Run Sta Sto		
Sequence ID/ Work Center II 270 HandFinish Hand Finishing)	2-Install ring A/R□□Sika Sikaflex exp 3-Inspect fo 4-Spray ins A/R	arpads & gaskets as per D g as per Dwg D3274 fflex-291	1 024 f web with LPS-3 1/4 x. Clean excess adhesive.	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	00.00 COLU	123			-(40)	<u> </u>		

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Work Order ID 63370

Thursday, October 28, 2010 10:13:41 AM



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Item ID:

D206-642-541

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

OC:

Process Plan: Date:

Operation

Description

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run

Start

Stop



Stop

Sequence ID/ Work Center ID

290

Packaging

Identify as per dwg & Stock Location:

Date:_____

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

300

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

CK 10/12/13 Mr 10-12-10

Quality Control

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W/O:			WO	RK ORDER CHANGE	S				,
DATE	STEP	PRO	CEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

Thursday, October 28, 2010 10:13:45 AM

Work Order ID: 63370

Parent Item:

D206-642-541

Parent Item Name:

Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Start Oty: 1.00

Required Qty: 1.00

Page 1

Comments:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C 07-02-23 IPP Rev:D 07-12-06

Added SS Wearplates & Gaskets JLM replace NAS1515H3L to D3672-1 DD

IPP Rev:E 08-04-17

as per PAR 08-015 DD verified by:EC

IPP Rev:F 08-06-02 IPP Rev:G 08-10-09

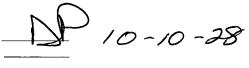
add comment DD verified by:EC revise details DD verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190		Manufactured	No			110	Each	63.0000	1 	1			

Extrusion Round 3" 206

Locat	<u>ion</u>
LG	
	<u>47575</u> 59874
	39074

Loc Qty 63 15 48 Each 141.0000



D3285-1

D3282-041

Manufactured No

Manufactured

110



Cap

Location	<u>Lo</u>	c Oty	Loc Code
LG		141	
52511		74	
52647		67	
	150	Each	0.0000



Float Web (206L/407)

Dart Ae	rospace L	td							
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Reso	olution:	Disposition	n:	QA: N/C CI	osed:	****	Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NCF	R)			
DATE	STEP	Description of NC Section A	Description of NC Section A Corrective Action Initial Chief Eng Chief E		Sign 8		cation ion C	Approval Chief Eng	Approval QC Inspector
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Picklist Print Thursday, October 28, 2010 10:13:45	AM						Page 2
Work Order ID: 63370 Parent Item: D206-642-541 Parent Item Name: Replacement Skidte	ube			18 18 18 18 18 18 18 18 18 18 18 18 18 1		Start Date: 10/28/201 Start Qty: 1.00	0 Required Date: 11/11/2010 Required Qty: 1.00
D2649 Cross Bolt Spacer	Manufactured	No		190	Each	107.0000 12 12	
Closs Buil Space			Location LG 58545 60652 61496	<u>Loc Q</u>	107 2 4 13	Loc Code & 633.	59 12 Bergn/.
D3275-1 Crossbolt Spacer	Manufactured	No	62889	190	88 Each	216.0000 12 12	
			Location LG 53453 61646 62399		216 8 102 106	Loc Code	2 DE Johnho
CR3212-4-03 Cherry Rivet	Purchased	No		250	Each	1,874.000 2 2	2 8E10/11/18
			Location ST311 111359 112314 114436 114450 114859			<u>Loc Code</u>	7

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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NCR:			WORK OR	DER NON-CONF	ORMANCE	(NCR)							
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			Office Ling	Office Ling		Date								

Picklist Print								Page 3
Thursday, October 28, 2010 10:13:45	AM							1 age 3
Work Order ID: 63370								g
Parent Item: D206-642-541								l .
Parent Item Name: Replacement Skidtu	ıbe			1000 1000 1000 1000 1000		Start Date: Start Qty:		Required Date: 11/11/2010 Required Qty: 1.00
D3415-041 Nut Plate	Manufactured	No		250 F	Each 5	2.0000 1	H 1	0/11/22
			Location	Loc Qty	<u>Lo</u>	oc Code		
000044000			ST056 33842	52 52	2		_X Z	
CCR264SS3-3	Purchased	No		250 E	Each 4	16.0000 2	2 	10/11/22
			<u>Location</u>	Loc Qty	<u>Lo</u>	c Code		
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ALS4-1032-130	Purchased	No				,653.000 78	78 HJ 10	11127
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Work Order ID: 63370								
Parent Item: D206-642-541								
Parent Item Name: Replacement Sk	kidtube	(1411116)	***************************************		-1	Start Date:	10/28/2010	Required Date: 11/11/2010
						Start Qty:	1.00	Required Qty: 1.00
D3536-15	Manufactured	No		270	Each	18.0000 1	1	
Gasket ·							110	111/27
			Location	Lo	c Oty	Loc Code		
			FP		6	B63568	X (_
			56055 60875		1 5			-
			FP11		12			- -
			59238		1			_
D3536-23		> 1	62459	200	11			-
	Manufactured	No		270	Each	3.0000 1	1	
						1 (46) (5)	M,	0/11/22
			Location	Lo	c Oty	Loc Code	•	
			FP011		3			_
			61237		3	1363238	X /	
D3536-35	Manufactured	No		270	Each	16.0000 1	1	
Gasket							Hl 10'	1110 22
			Location	<u>Lo</u>	c Oty	Loc Code		
•			FP012		16	1363579	<u> </u>	_
			58683 61692		1 3			- ,
			62462		12			
D3536-39	Manufactured	No		270	Each	12.0000 1	1	
Gasket							<u> </u>	10/11/22
•			Location	<u>Lo</u>	c Oty	Loc Code B 63578		
			FP12		12	B 63578	<u> </u>	
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Work Order ID: 63370				<u> </u>					\overline{q}
Parent Item: D206-642-541 Parent Item Name: Replacement Skid	ltube		18 (18)				10/28/2010	Required Date: 11/11/2010	
D3535-15 Wearshoe	Manufactured	No		270	Each	22.0000	tart Qty:	1.00 1 	Required Qty: 1.00
D3535-35	Manufactured	No	Location FP18 61241 62241 62707	<u>Lo</u> 270	22 6 3 13 Each	<u>Loc Code</u> 26.0000	1 		- - - -
D3535-39	Manufactured	No	Location FP018 60865 62461 62969	<u>Lo</u> 270	26 6 12 8 Each	<u>Loc Code</u> 27.0000		У(
Wearshoe	ivianuraciui eu			270	Lacii	27.0000		<u> </u>	olulzz

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Picklist Print Thursday, October 28, 2010 10:13	·45 4M										Page 6
Work Order ID: 63370											9
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Parent Item Name: Replacement S	kidtube					•		tart Date: 1 Start Qty: 1		Required Date: 1 Required Qty: 1	
D3535-23 Wearshoe	Manufactured	No			270	Each	28.0000	1	HI 1	0111/22	
Treat Stroc			Locatio	<u>n</u>	Lo	c Oty	Loc Code				
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				61830		6			~~~~	_	
			FP021	<		21				_	
				60231 62706		8 13				_	
D3537-3	Manufactured	No		02700	270	Each	40.0000	1	<u>H</u> ,	0/4/22	
Wearpad			Location		Lo	c Qty	Loc Code				
			<u>Locatio</u> FP17	<u>II</u>	1.0	40	Loc Code				
			1117	60866		3				_	
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D2527 1		NT.		62705	370	20	((,0000	0	<u></u>	_	
D3537-1	Manufactured	No			270	Each	66.0000	9	9 <u>JU</u>	10/11/27	
Wearpad			Locatio	o <u>n</u>	<u>Lo</u>	e Oty	Loc Code	i.			
			FP			1	Loc Code	-928	x q	_	
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Parent Item:	D206-642-541			10 1101						
Parent Item Name	e: Replacement Skidtu	ibe	7 IBBII(18 IB	18			St	art Date:	10/28/2010	Required Date: 11/11/2010
							S	Start Qty:	1.00	Required Qty: 1.00
AN960C10L	NAS1149C0332	Purchased	No		270	Each	29.0000	80	80	
									C 2 . 11) .
i (Milia) i Milai Ria (Mila Milia) washer	BIORI IION MAHA BANGAN AN IORI				٨٨	11583	7		LL 08 x	10/11/22
				Location	Loc	<u>Oty</u>	Loc Code			
				ST245		29			-	_
AN960C416	NAC1140C0462		NI.	107534	270	29	20.0000			-
	NAS1149C0463 R	Purchased	No		270	Each	30.0000	1	1	
					M 115	7			xiell,	0/11/27
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				ST346 100993		30 30			· · · · · · · · · · · · · · · · · · ·	-
D3672-1		Manufactured	No	100773	270	Each	847.0000	2	2	-
										10/11/22
Phenolic Washer	(a) ::aaa (ta) :50)									1011112
				Location	Loc	<u>Oty</u>	Loc Code			
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Work Order ID: 63370 Parent Item: D206-642-541			TO 1/14 1/1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 10 1/1 To 1/14 1				9
Parent Item Name: Replacement Sk	idtube				Start Date: Start Qty:		Required Date: 11/11/2010 Required Qty: 1.00
AN3C4A	Purchased	No		270 Each	2,233.000 80	80 JL 101	11/22
			Location ST303 115438 ST350 114108 114416 114523 115300 115589 115936	Loc Oty 3 3 2230 14 12 2 202 1000 1000	Loc Code	780	
AN4C5A	Purchased	No		270 Each	481.0000 1	1	0/11/27
			Location ST346 110552 112243	<u>Loc Oty</u> 481 4 477	Loc Code		
D2646 Aft Cap	Manufactured	No		270 Each	45.0000 1	1	111/27
			Location FP-4 57332 fp5 62652 FP6 52663	35 35 6 6 4 4	<u>Loc Code</u>	χΤ	

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Thursday, October 28, 2010 10:13:45 AM

Work Order ID: 63370

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Page 9

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Ring

Manufactured No 270

Each 23.0000

Location Loc Qty Loc Code ST473 23 51586 1 53446 7 61322 15

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	CHEC	(ED A	APPROVED 4	DRAWING NO. REV. D
ĺ		#	-#	D3274 SHEET 1 OF 4
	DATE			TITLE SCALE
	06.1	2.19		SKIDTUBE ASSEMBLY NTS
	Α		04.03.15	NEW ISSUE
	В		04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
	С		05.03.16	ADD -043; NEW INSERTS
	D		06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

DEO ATTACHED

Qty	Qty		
-041	-043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	Х	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37_	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

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GENERAL NOTES:

- 1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2. DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

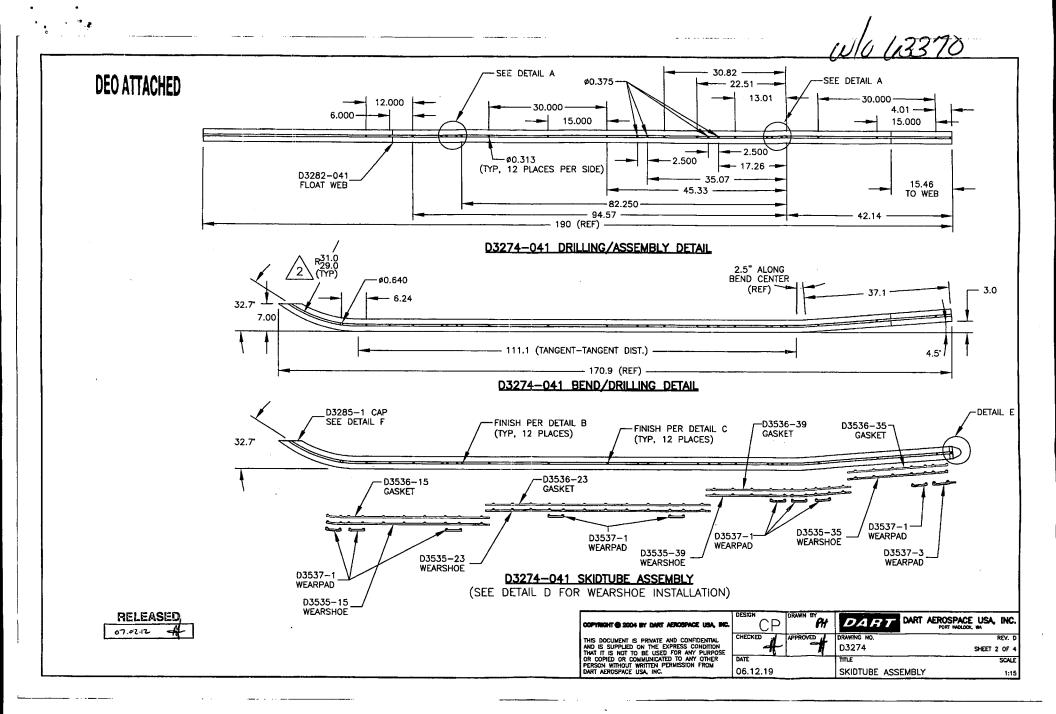
- 3. ALL HOLES DRILLED ON CENTERLINES.
- BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291
 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 5. WELDING TO BE DONE PER DART QSI 004.
- 6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- 8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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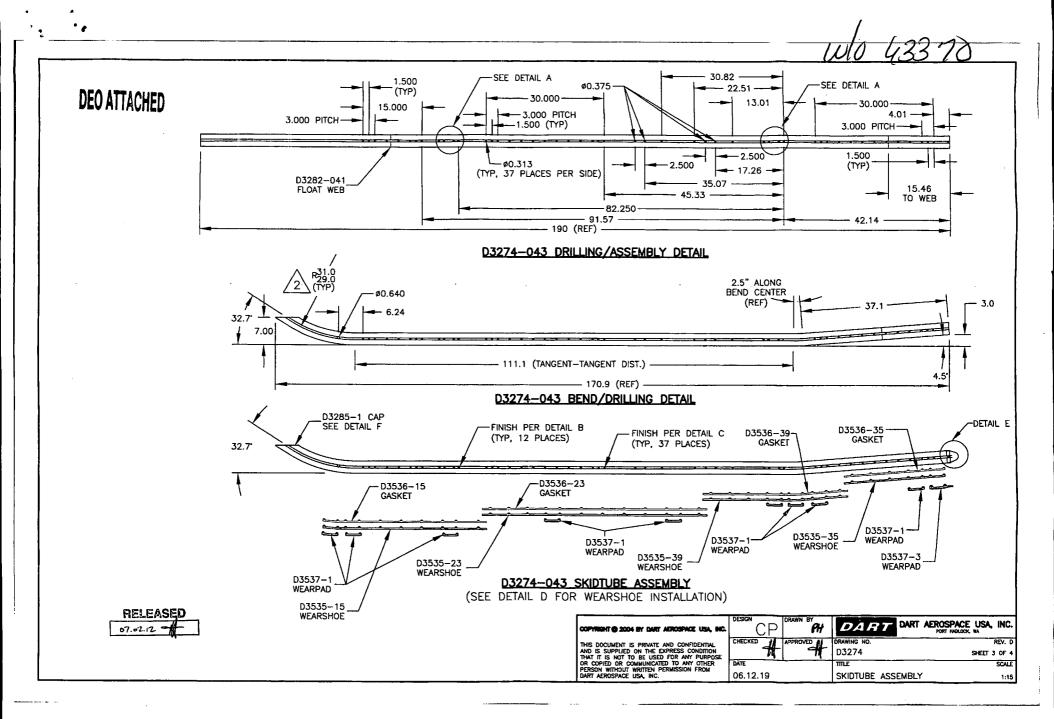
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Dart Aerospace Ltd

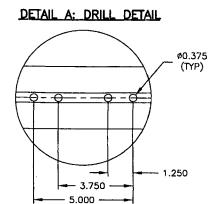
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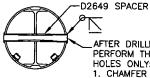
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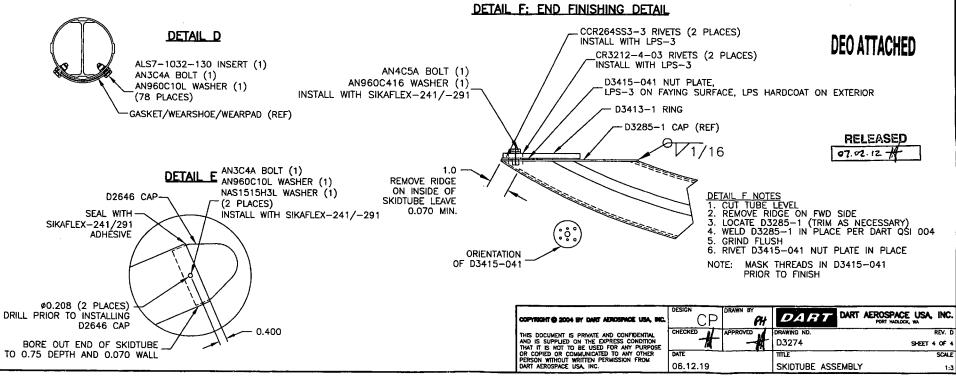
DETAIL B FOR 0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.375 HOLES ONLY:

- 1. CHAMFER HOLE 0.030x45°
- 2. INSERT D2649 SPACER
- 3. WELD INTO PLACE AND GRIND FLUSH
- 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C FOR Ø0.313 HOLES ONLY -D3275-1 SPACER CHAMFER 0.030x45* (TYP)



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGI	ES				5. 5.
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DRAWING	NO.	TITLE	, REV. D DA	RT AEROSPACE USA, IN	NC D.E.O. NO.	SHEET NO.	SCALE
D3274		SKIDTUBE ASSEMBLY		ENGINEERING ORDER	D3274-D-1	SHEET 1 OF 1	NTS
DRAWN	S	CHECKED	L I	MFG. APPR.	APPROVED , APP.	DE APPR.	,
DATE	09.06.	17 DATE 09.06	. 23	DATE 59/06/23	DATE 09/06/2	DATE 09 06.23	

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

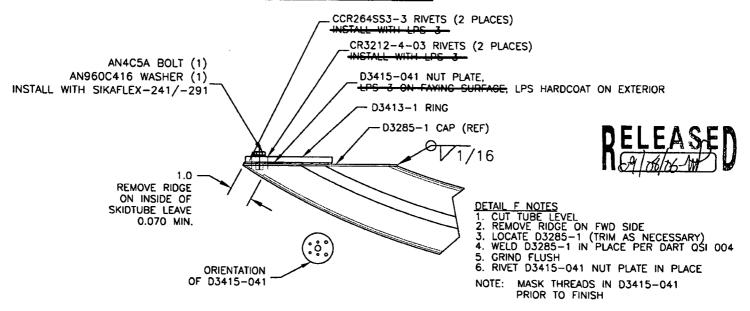
AMEND NOTE 8: "SPRAY-INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

wlo 43370

DETAIL F: END FINISHING DETAIL



Dart Aerospace Ltd

W/O:		/	WORK ORDER C	HANGES				
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NO. 241	NO.	241	
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AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Barclas El	l. o++
Job number: 622808	
Part number: DAOG 642.5	
Description: 206 skid	
Welding Process: Tig Mig	1
Base materiel: Auminian	.,
Current: AC DC]	

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[i] fail[] pass[] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier D. D	Date of Test Coupon 10.0930 Date of Test Coupon 10.0930

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.